

Work Order ID 125894

\*125894\*

Page 1

Friday, October 24, 2014 11:09:39 AM

Item ID: D2744 Accept \*N900040100\* Setup Start \*NS1\*

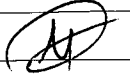
Revision ID: Stop \*NS2\*

Item Name: Cap

Start Date: 10/27/14 Start Qty: 50.00 \*50\* Cust Item ID:

Required Date: 11/21/14 Req'd Qty: 50.00 \*50\* Customer:

Reference:

Approvals: Process Plan:  Date: 14-10-24 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2744	Rev C

100	FLOW WATER JET	0.00				56	0		DAS 23 9-89 14-11-03
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\*100\*

Waterjet

FLOW CNC Waterjet

5052 080

Memo

1-Cut as per Dwg D2744

Dwg Rev: 2

Prog Rev: 2

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				56	0		DAS 23 9-89 14-11-03
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\*110\*

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00				56	0		DAS 38 9-89
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\*120\*

QC

Quality Control

Memo

NOV 05 2014

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 125894

\*125894\*

Page 2

Friday, October 24, 2014 11:09:39 AM

Item ID: D2744 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cap  
 Start Date: 10/27/14 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 11/21/14 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
*130*									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

56 0 14-11-13 BE

4/11/14 JG

4-11-13

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, October 24, 2014 11:09:43 AM

Page 1

Work Order ID: 125894

**\*125894\***

Parent Item: D2744

**\*D2744\***

Parent Item Name: Cap

Start Date: 10/27/14

Required Date: 11/21/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP C03.01.17Reformat; Dwg revisedKJ/RF  
IPP Rev:D Now on Waterjet 06-06-16 JLM  
IPP Rev:E As per Rev C 07-07-28 JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080		Purchased		No		100	sf	48.6300	0.1823	10' 12			DAS 23 9-89 14-11-03
<b>*M5052H32S 080*</b>													
5052-H32 .080 Sheet													

Location

Loc Qty

Loc Code

MAT022

48.63

124445

3.04

125552

45.59

125552.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**FAULT CATEGORY**

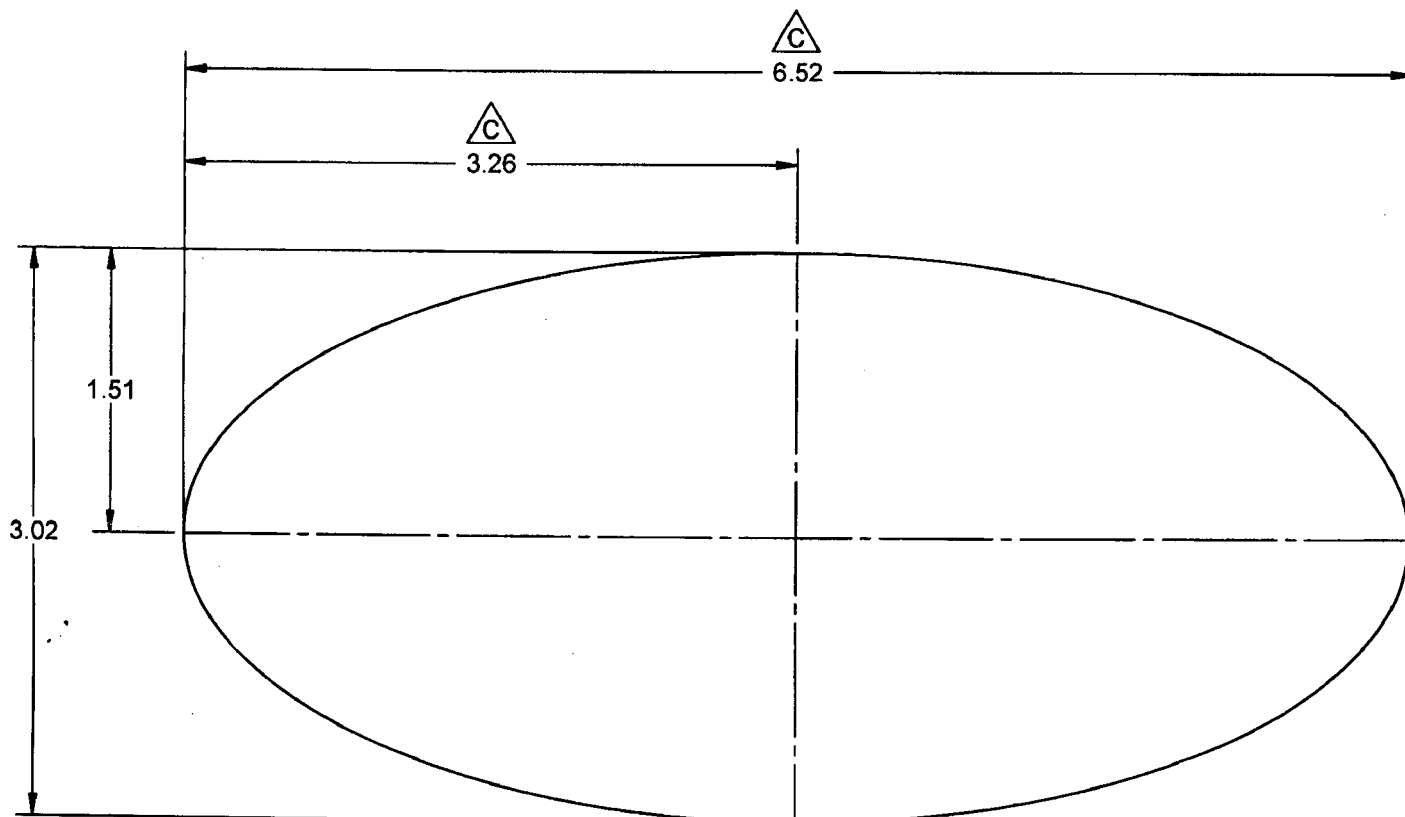
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DESIGN #	DRAWN BY CB	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. <b>D2744</b>	REV. C SHEET 1 OF 1
DATE <b>06.10.05</b>		TITLE <b>CAP</b> SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

**RELEASED**  
07-08-02 #



**D2744 CAP**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.080)  
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016  
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

*Handwritten signature and date:*  
14-10-24  
125894

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